

Work Order ID 52648

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October 5, 2009 2:52:22 PM

Item ID: D2617-5

Accept



Setup Start



Revision ID: D2

Stop



Item Name: Spacer

Start Date: 06/10/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 13/10/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: *PL*Date: *09-10-5*

Tooling: _____ Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2617	Rev D2

100



Hardinge CNC LATHE SMALL

0.00

0.00

PL 09/10/11
100 S

Hardinge

Memo

Hardinge CNC Lathe Small

1-Machine as per Folio FA438 and Dwg D2617-2-Deburr

110



QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

PL 09/10/11
100 S

QC

Memo

Quality Control

120



QC8- Inspect parts - second check

0.00

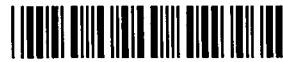
0.00

PL 09/10/11
102 S

QC

Memo

Quality Control

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Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

UMD 09110116



HandFinish

Memo

0.00

X102

Hand Finishing

140

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

102

150

Identify as per dwg & Stock Location: 39

0.00

Packaging

Memo

0.00

Packaging

9/10/16

102 S

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Stop



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Cust Item ID:

Required Date: 13/10/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/10/19 HJ

MF
09-10-19

Picklist Print

October 5, 2009 2:52:22 PM

Page 1

Work Order ID: 52648



Parent Item: D2617-5RevD2



Parent Item Name: Spacer

Start Date: 06/10/2009

Required Date: 13/10/2009

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T0.500W.058		Purchased	No			100	f	439.0500	0.8211			

6061-T6 RD Tube .500 x.058W



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	439.05	
110335	0.6	
111757	11.61	
112652	126.84	
112800	300	

Re/5 PT SA 09/10/11

DART AEROSPACE LTD	Work Order:	526418
Description: Bushing	Part Number:	D2617-5
Inspection Dwg: D2617 Rev: D2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

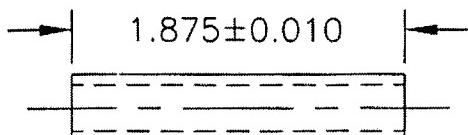
Measured by:		Audited by:		Prototype Approval:	N/A
Date:	09/10/11	Date:	09/10/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.09	New Issue	KJ/JLM	
B	06.03.09	Dwg Rev change	KJ/JLM	
C	08.01.16	Tolerance revised for 0.500 dimension	KJ/EC/DDC	N

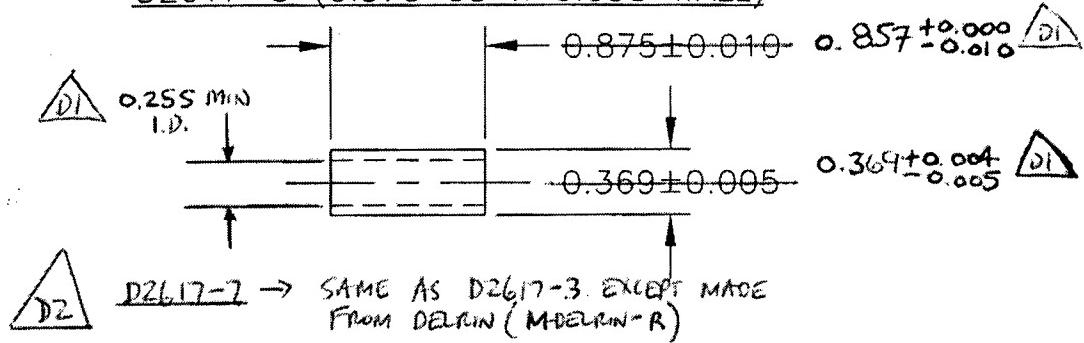


DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D2617 REV. D SHEET 1 OF 1
DATE	01.07.04	TITLE	BUSHING	SCALE 1:1
D2 04.09.10 CP	ADD D2617-7	A	96.10.08	NEW ISSUE
		B	97.05.08	.875 WAS 1.125
		C	97.06.04	0.369 DIA WAS 0.375
		D	01.07.04	ADD MAT'L SPEC AND TOL./DIM. NOTE
		DI	CP-# 04.07.12	CORRECT TOLERANCE (NCR 779)

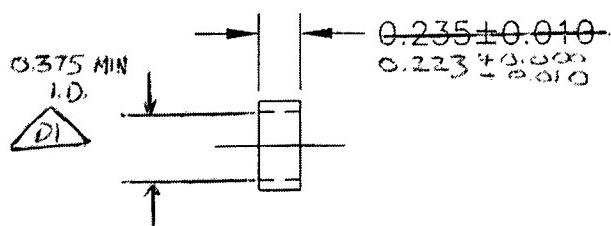
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



RELEASED
01.07.05 CP

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52448
BY 09-10-5

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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